

Blue

## Work Order ID 53355



Page 1

November 2, 2009 10:43:17 AM

Item ID: D3414-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

*PT*

Date:

*07-11-2*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 2.50" x 0.500" x 2.250" long

*DIT 09/11/10**20*

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA569 and Dwg D3414  
Identify as D3414-3 □ Dwg Rev *B* Folio Rev *AA**DIT 09/11/10**20*

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*DIT 09/11/10**20*

# Work Order ID 53355

November 2, 2009 10:43:17 AM



Page 2

Item ID: D3414-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8809/11/11

Quality Control

140

Identify as per dwg & Stock Location: encl 0.00



Packaging

Memo

0.00

Packaging

welding  
use for D3414-041 B53354

9/11/11 SC (20x)

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/11/11 JF  
yrf  
09-11-11.

# Picklist Print

November 2, 2009 10:43:21 AM

Page 1

Work Order ID: 53355

Parent Item: D3414-3RevC

Parent Item Name: Lug


Comments:

Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 20.00

Required Qty: 20.00

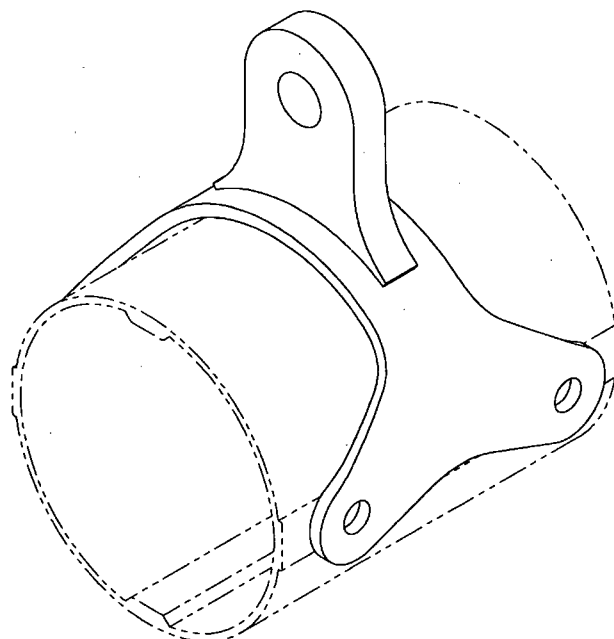
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	84.7415	3.7500			
												
304 BAR .500 x 2.50												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	84.7415	
110966	2.9	
111330	3.16	
112320	12	
112347	9.6465	
112697	12.1	
112764	39.065	
18929	5.87	

3.75(4) JN 09/11/10



ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



**D3414-041 LUG ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

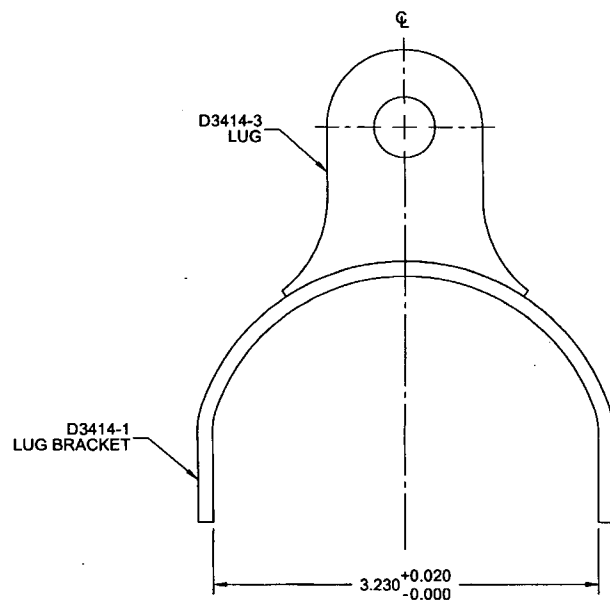
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*PA 09-11-2*

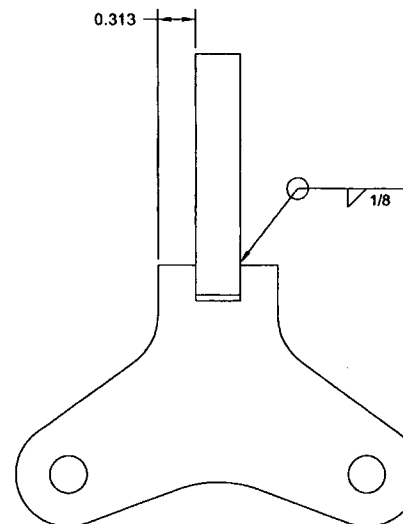
**RELEASED**  
*29/06/05*

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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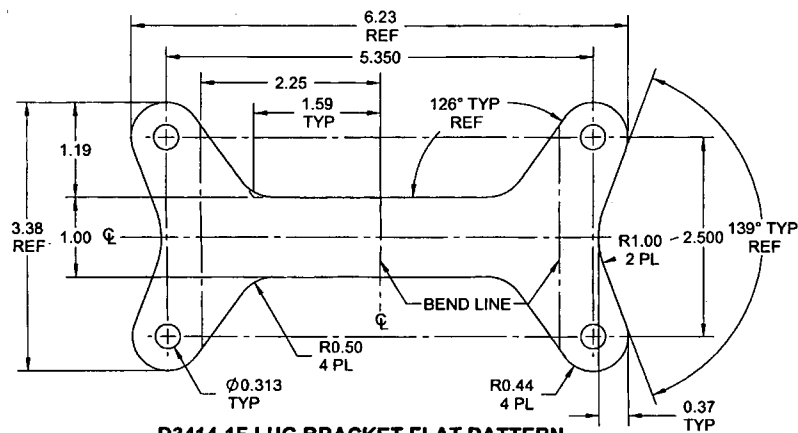


**D3414-041 LUG ASSEMBLY**

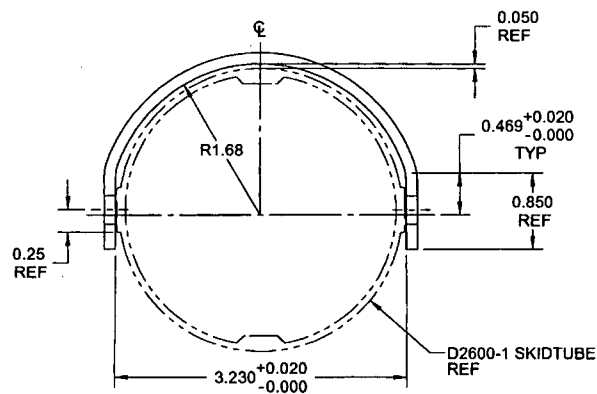


**RELEASED**  
 04/18/25

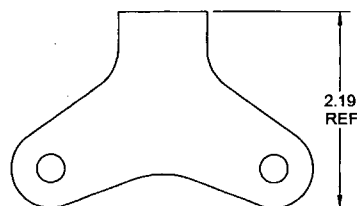
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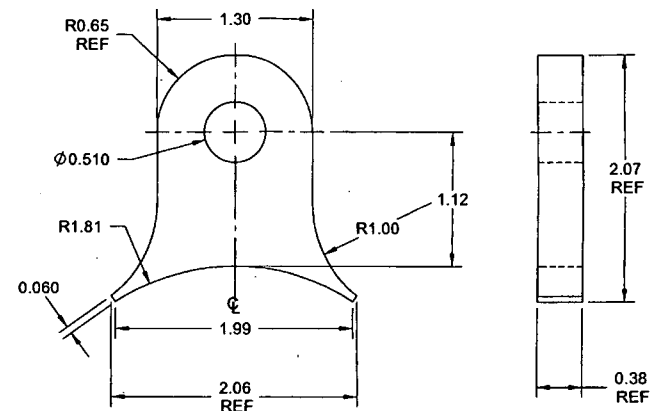
**D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**



SIDE VIEW FOR REF ONLY



**D3414-3 LUG**

**NOTES:**

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX  
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

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CHECKED		DRAWING NO. <b>D3414</b>	REV. C
MFG. APPR.		SHEET 3 OF 3	
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DE APPR.		<b>LUG ASSEMBLY</b>	NTS
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